

Date: Friday, 28/11/2008 2:54:19 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B HIGH GEAR WEB		
Job Number	: 43850		Part Number	: D26543		
Estimate Number	: 10455		Drawing Number	: D2654 REV E1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 28/11/2008	S.O. No. :	Drawing Revision	: E1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SKIDTUBES	Due Date	: 10/12/2008		
Previous Run	: 43805		Qty:	6 Um: Each		
Written By	:					
Checked & Approved By	: <u>Julie Dawson</u>					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		Pick:	
	Qty	Part Number	Description
	1	D2600-5	Batch <u>38589</u>
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Cut D2600-5 to length as per Dwg D2654	
		2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654	
		3-Using the uni-bit, open holes to finish size as per Dwg D2654	
		4-Deburr holes and ends	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 43850

Part Number: D26543

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



DP



6

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8-12-8

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L-G.

AM

8-12-08

6PC5

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/09 JF

Job Completion



MF 08-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

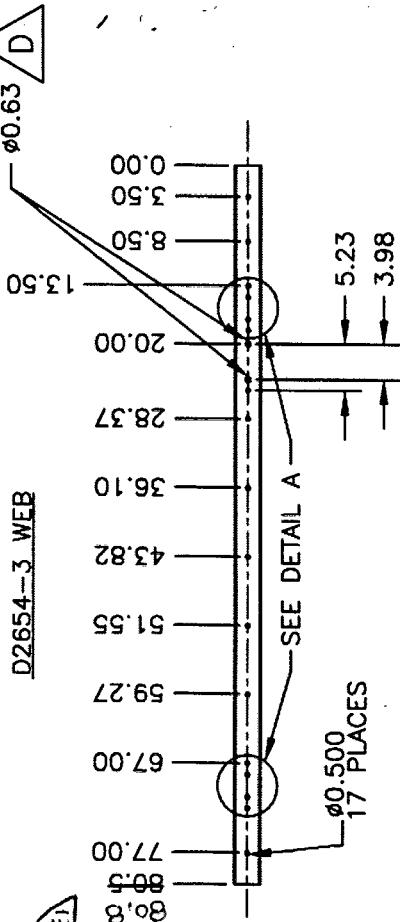
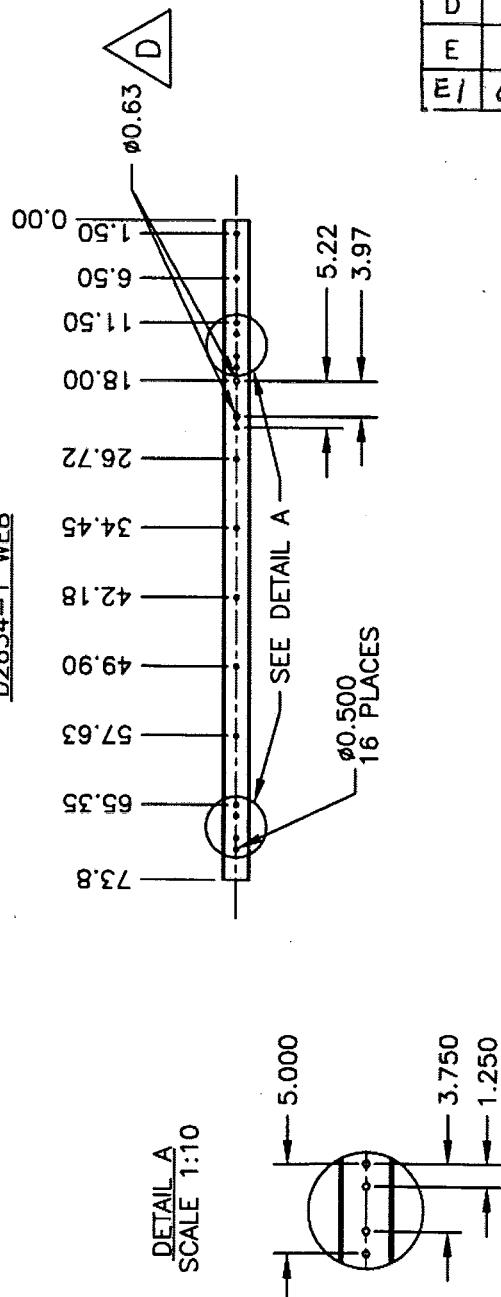
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB
04.05.26		SCALE 1:20

A 97.03.25 NEW ISSUE
 B 97.06.26 ALTER HOLE PATRN., 0.500 WAS 0.438
 C 97.10.29 CHANGED HOLE PATTERN
 D 98.01.15 GHW HOLES CHANGED TO \varnothing 0.63
 E 04.05.26 CHANGE LENGTHS, REFORMAT
 E1 04.08.04 PER TOOLING; 80.8 WAS 80.5

RELEASED
04.06.22

D2654-1 WEB



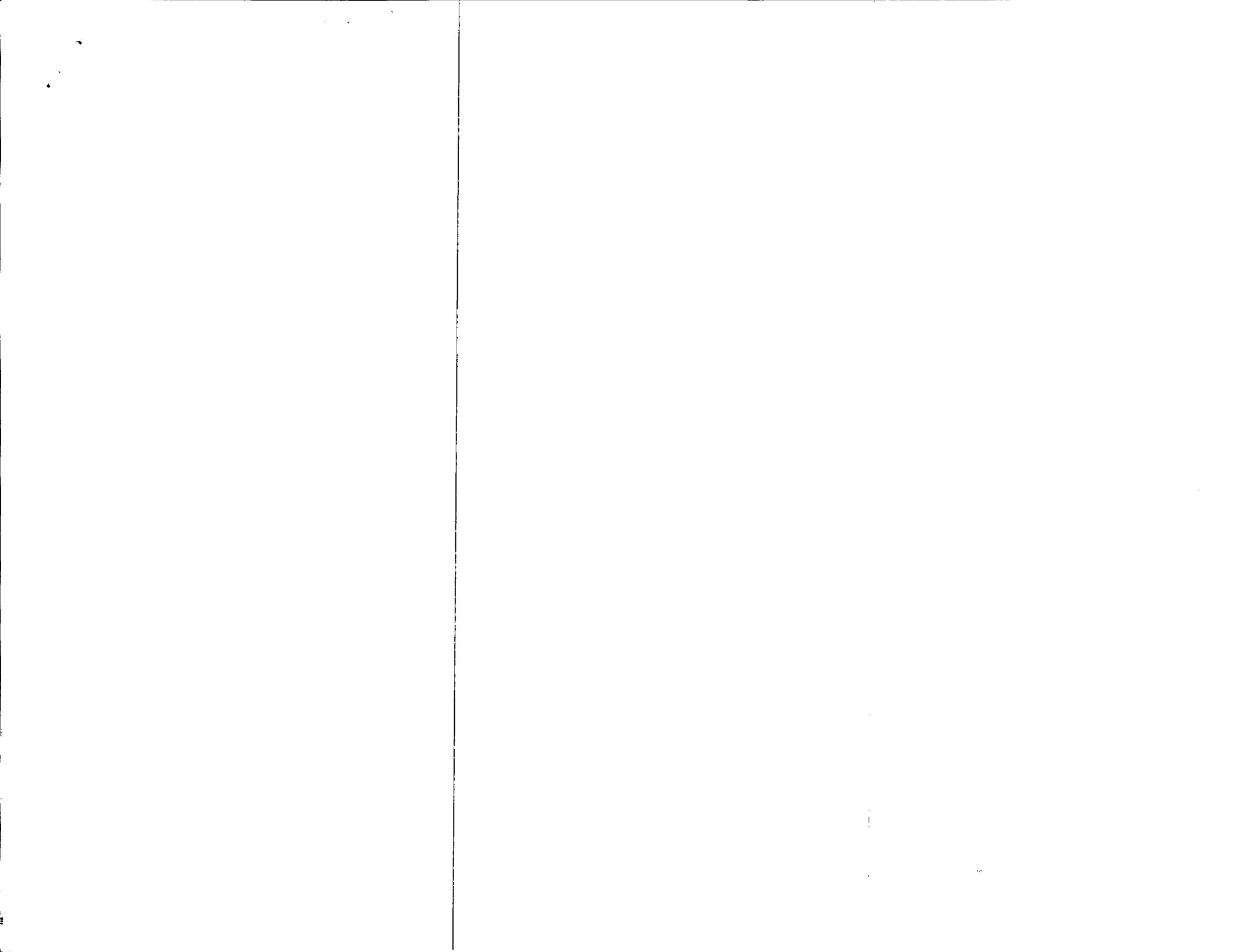
MAKE FROM D2600-5-108 EXTRUSION
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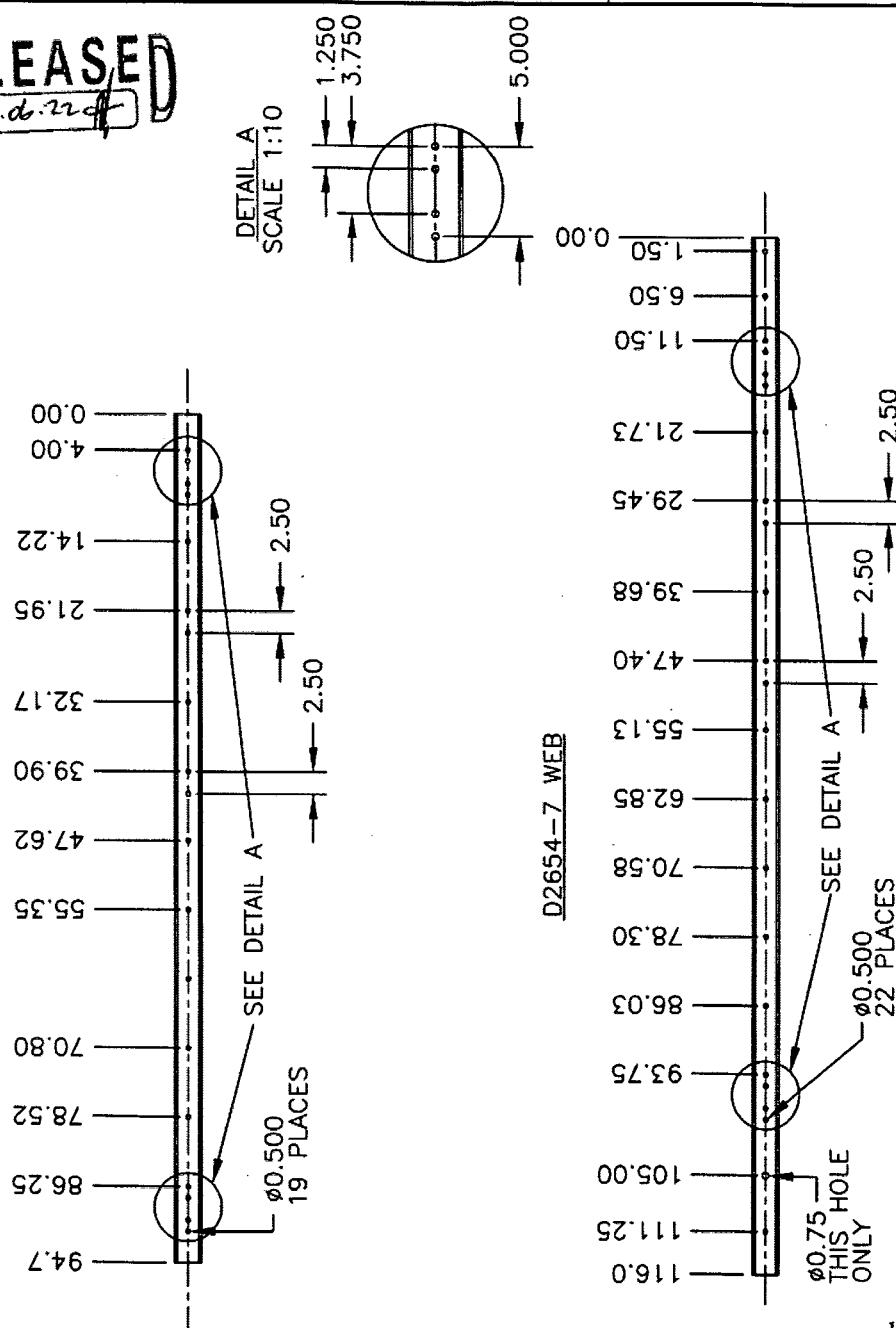


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DATE	04.05.26	TITLE WEB SCALE 1:20

RELEASED
04.06.22

D2654-5 WEB



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